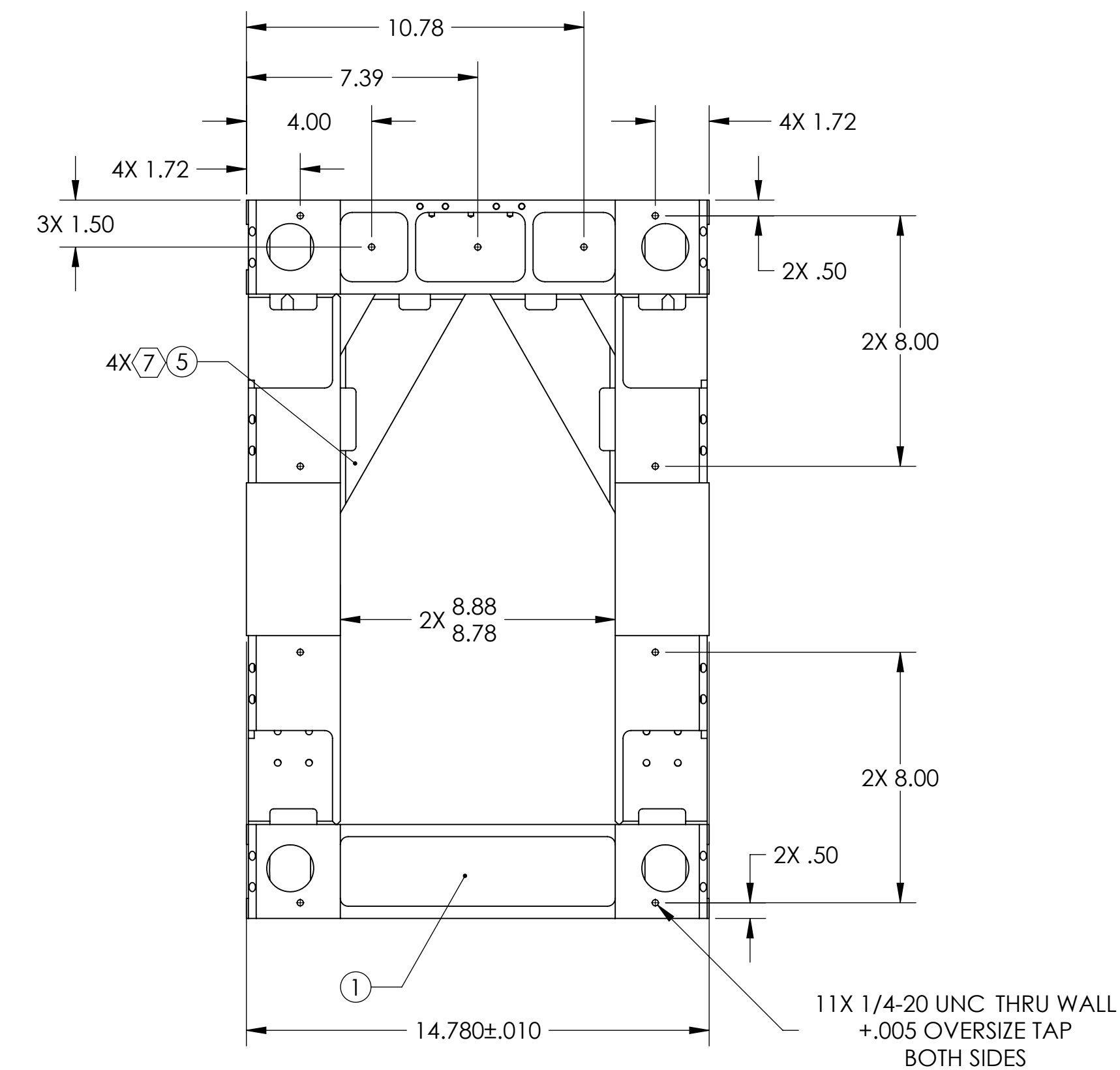
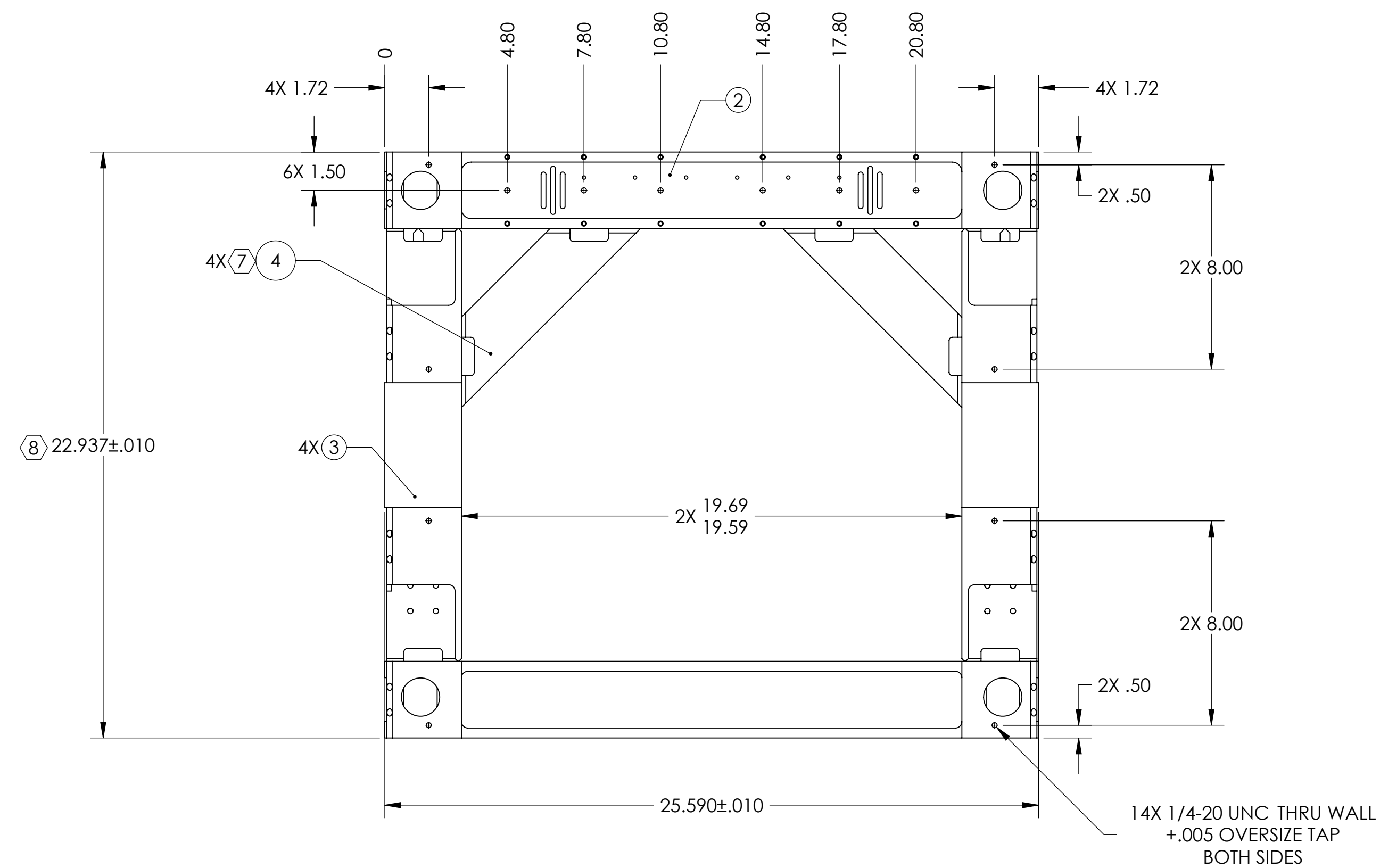


NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
 6. FABRICATE WELDMENT IN ACCORDANCE WITH LIGO E0900048.
 ⑦ POSITION FLUSH TO THE INSIDE SURFACE OF F/N 2.
 ⑧ AFTER WELDING, MACHINE INDICATED SURFACES TO ACHIEVE NOTED DIMENSIONS.

REV.	DATE	DCN #	DRAWING TREE #
v1	16 APR 2009	E0900106	E0900052
v2	11 AUG 2009	E0900238	E0900052
v3	10 FEB 2010	E1000033	E0900052
v4	02 MAR 2010	E1000060	E0900052



QTY	PART NUMBER	DESCRIPTION	MATL	F/N
4	D0900350	7" X 4" GUSSET	6061-T6 AL	5
4	D0900349	7" X 7" GUSSET	6061-T6 AL	4
4	D0900348	LEG, OMC STRUCTURE	6061-T6 AL	3
1	D0900347	TOP PLATE, OMC STRUCTURE	6061-T6 AL	2
1	D0900346	BASE PLATE, OMC STRUCTURE	6061-T6 AL	1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .01 .XXX ± .005	
ANGULAR ± .5°	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS SHALL BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE AND SILICONE, SUCH AS CINCINNATI MILACRON'S CIMTECH 410.	
MATERIAL	FINISH
6061-T6 AL	32 μinch

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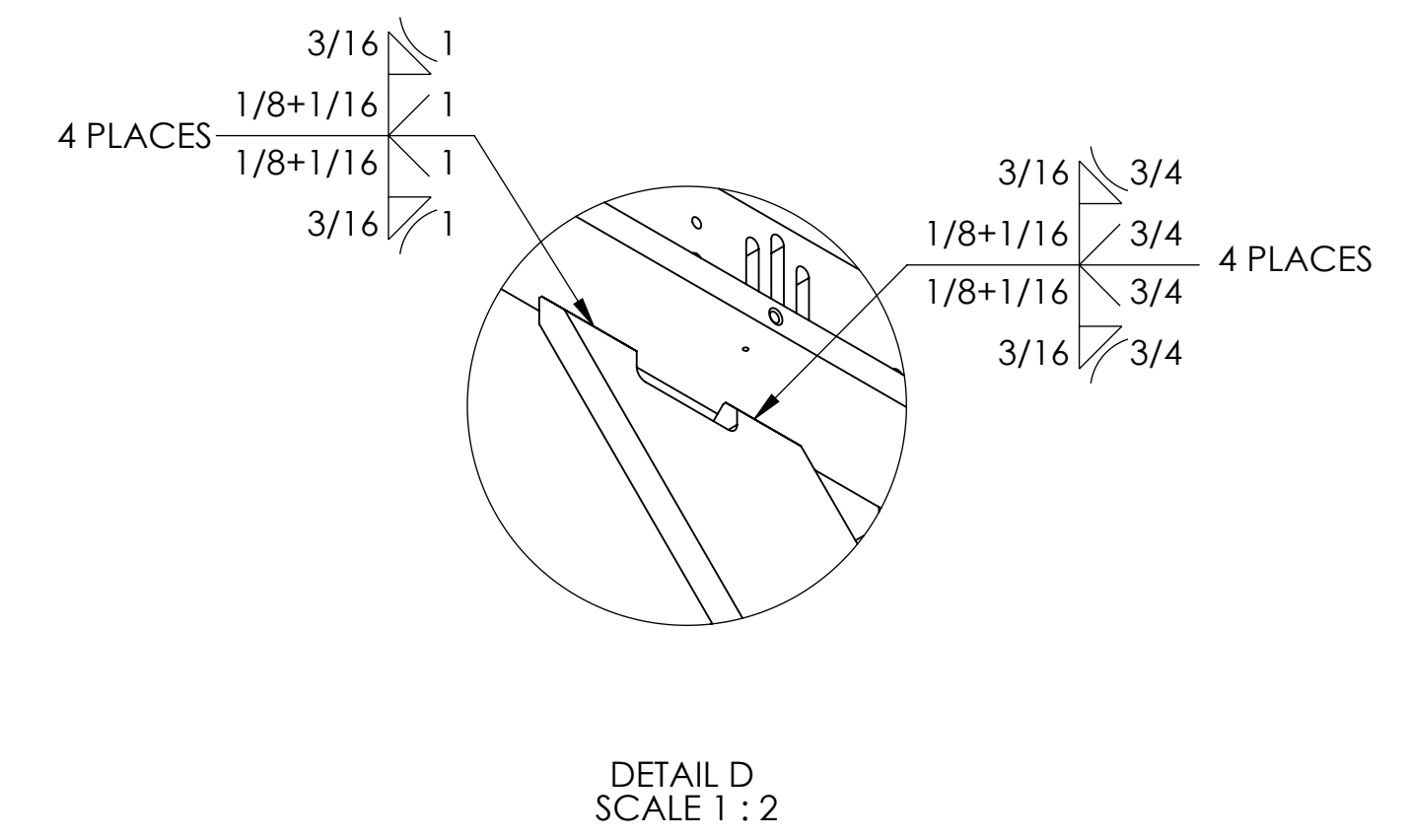
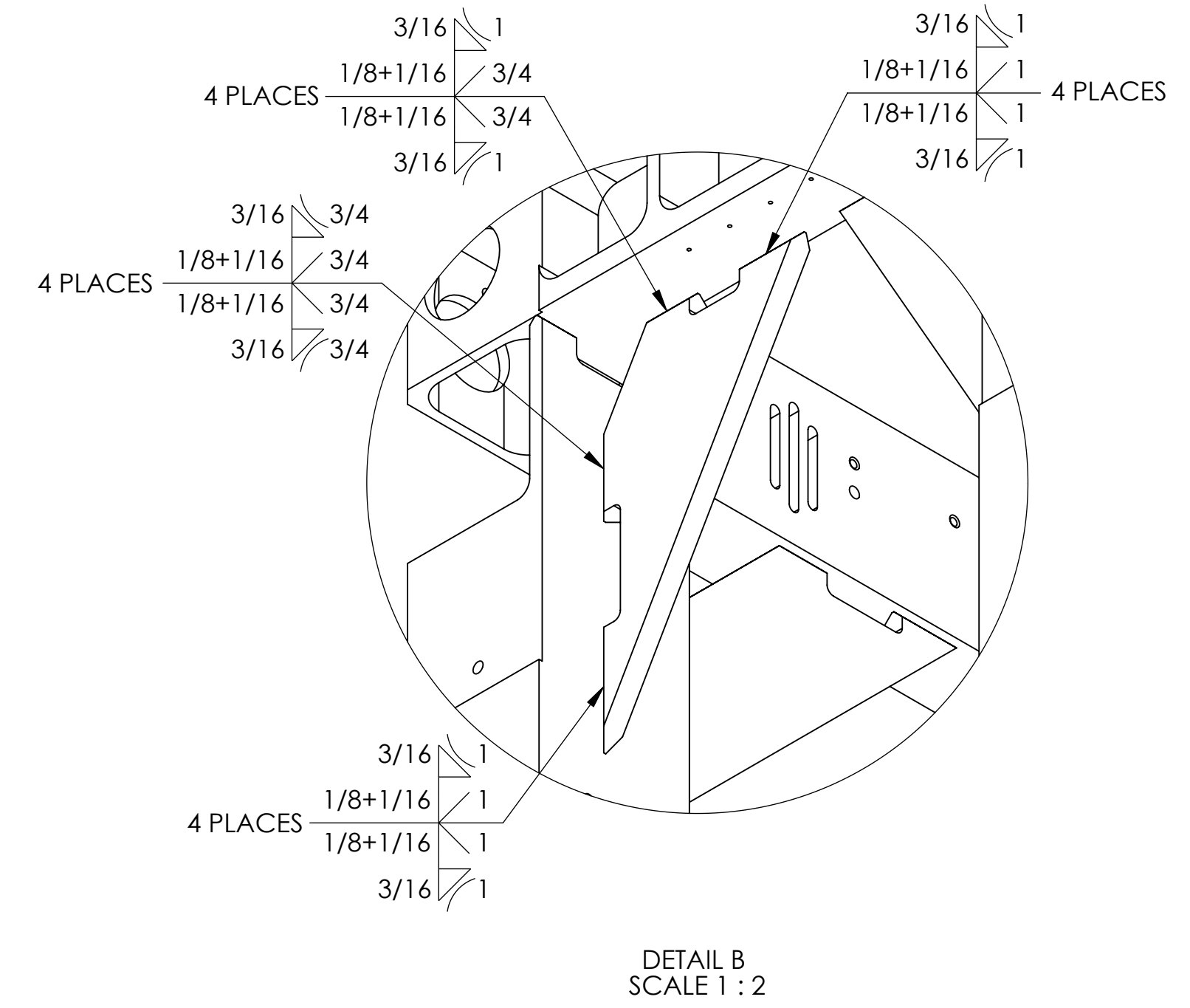
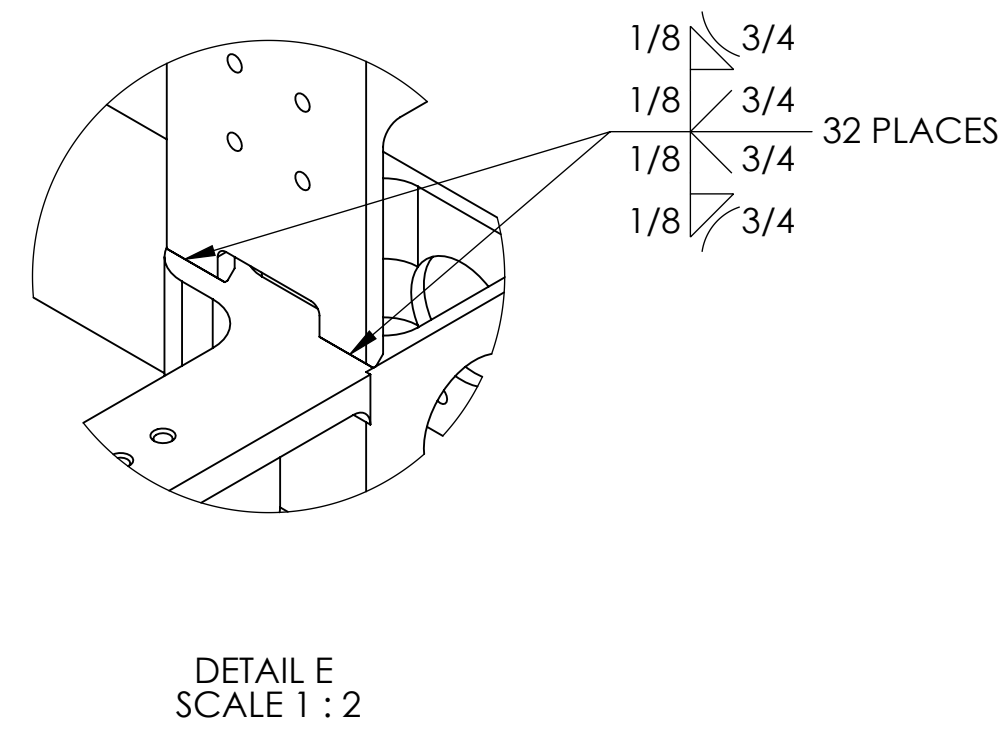
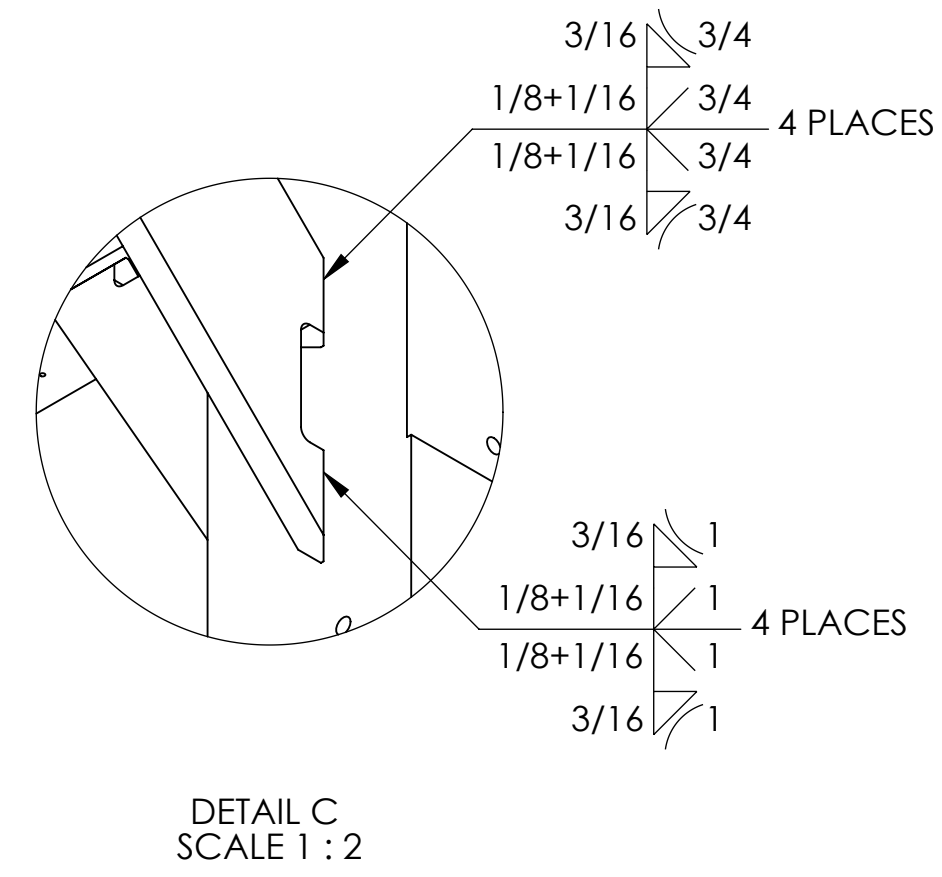
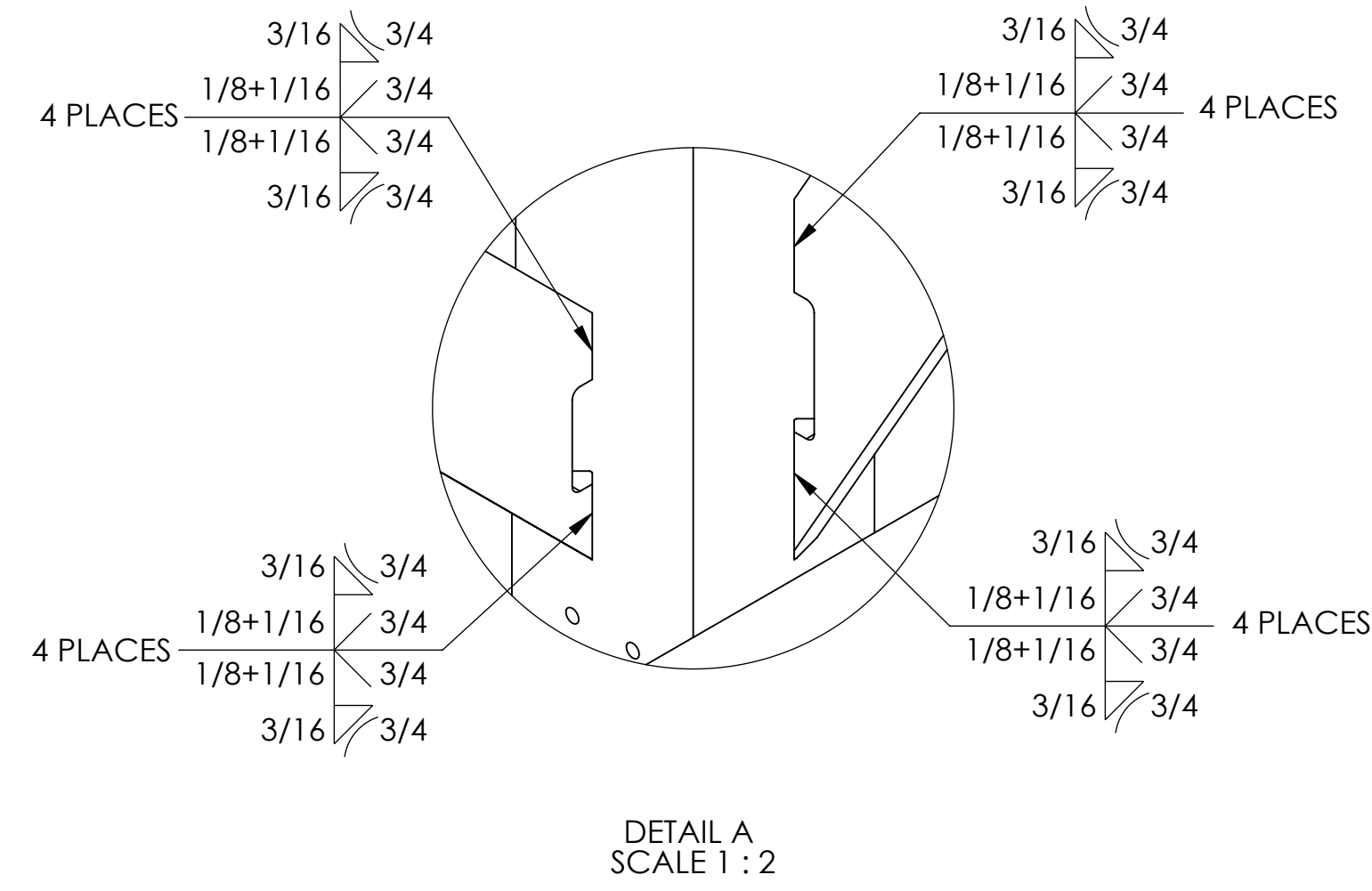
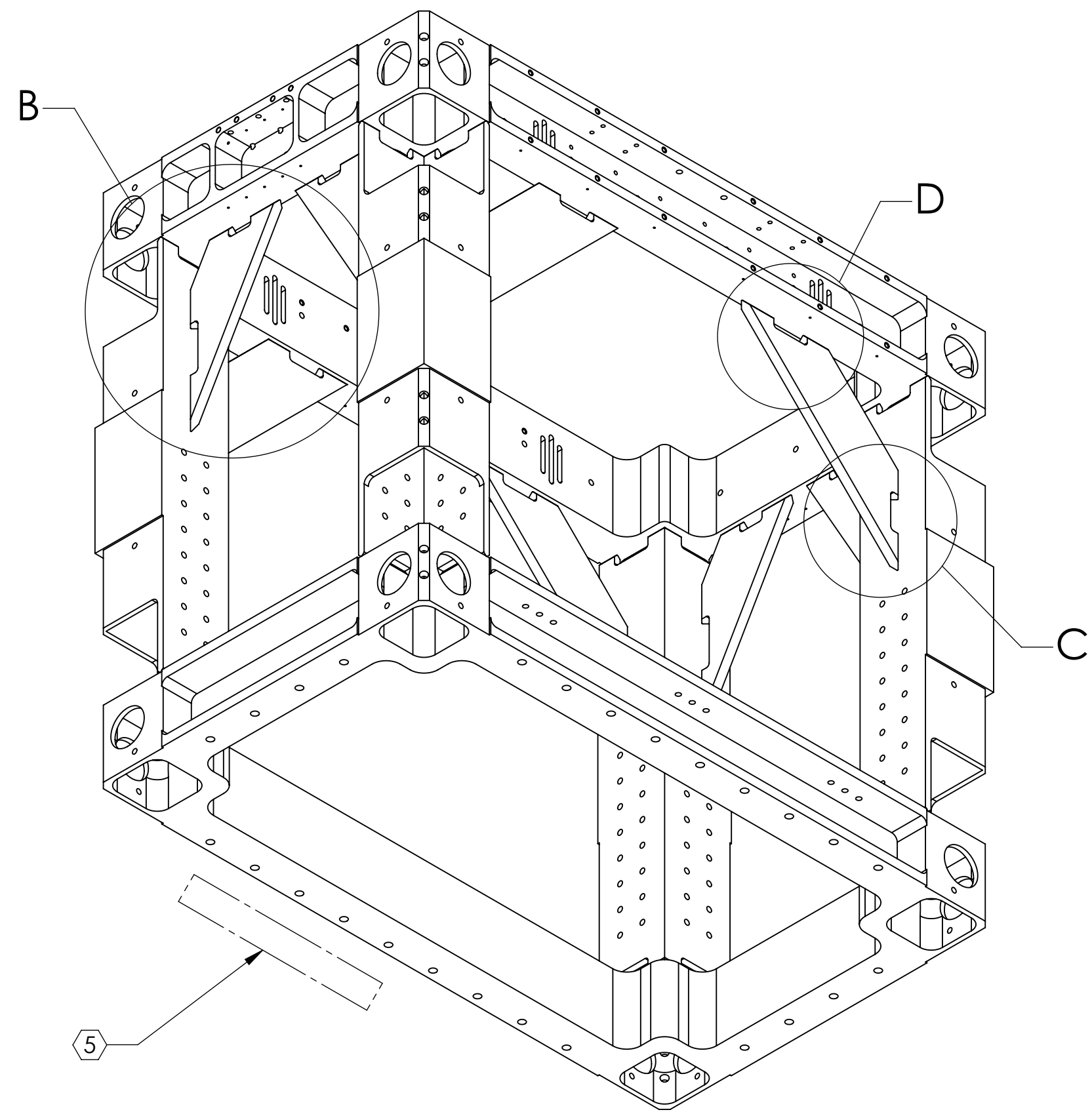
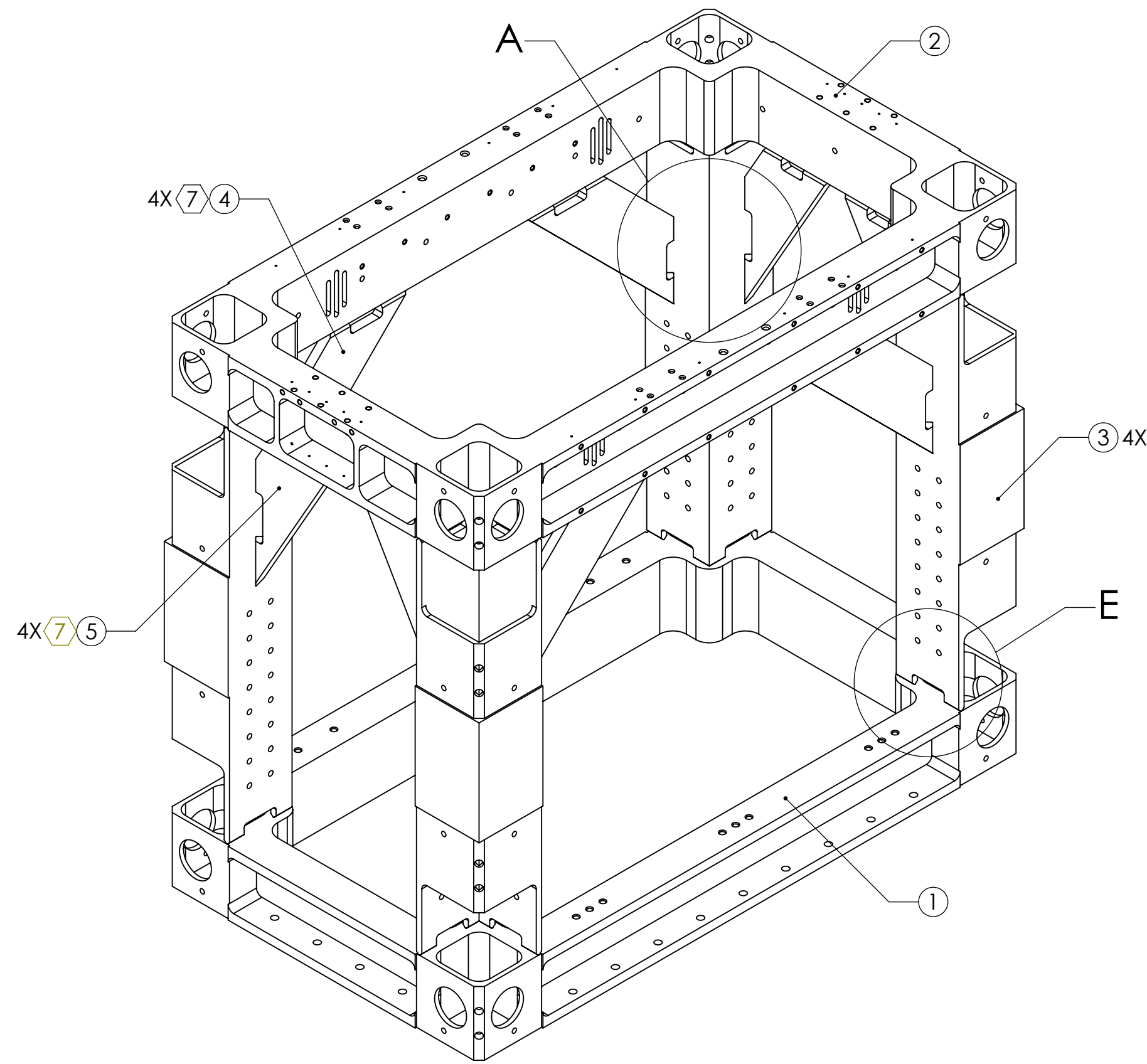
SYSTEM: ADVANCED LIGO SUB-SYSTEM: SUS

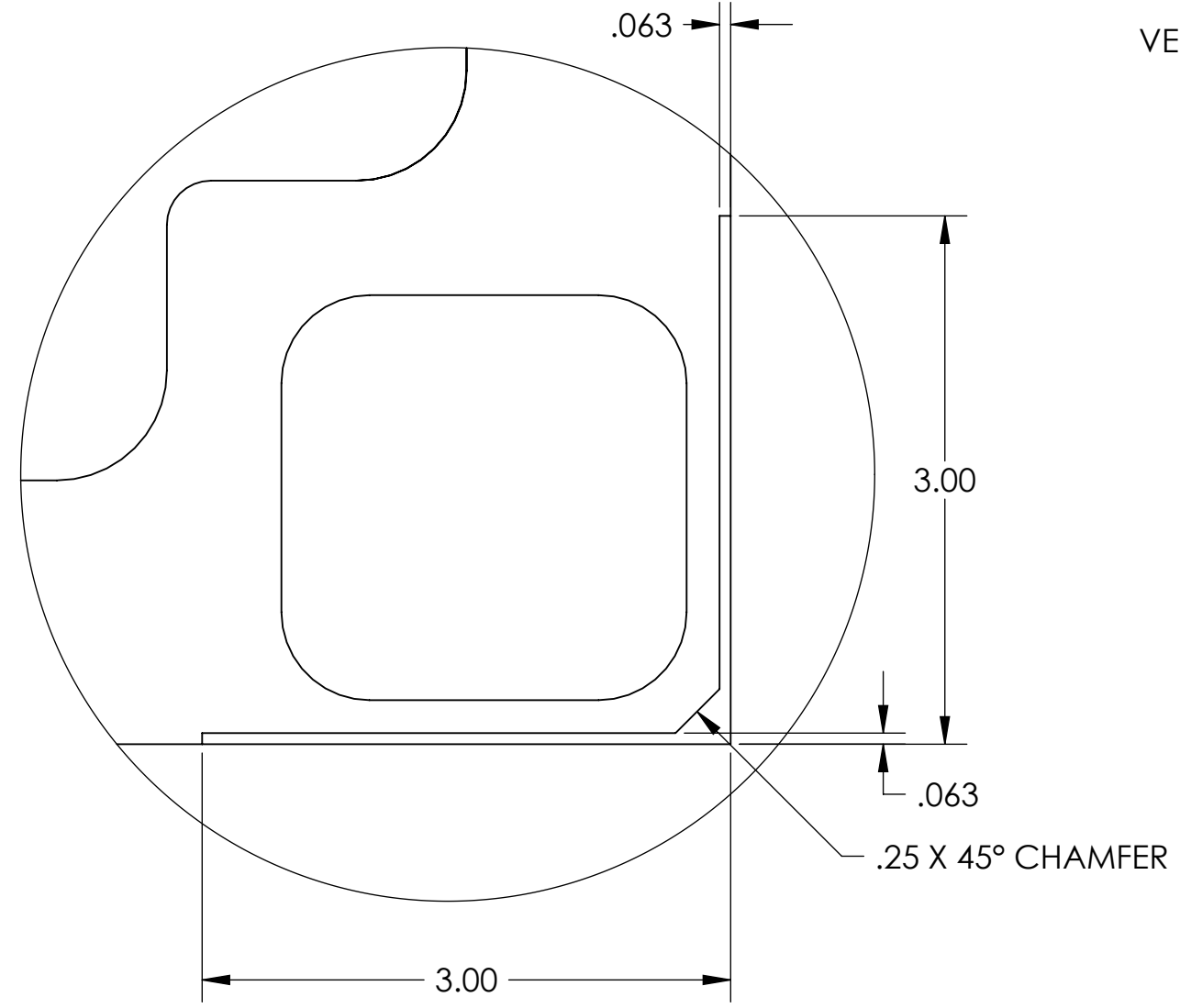
NEXT ASSY: D0900655

PART NAME: OMC STRUCTURAL WELDMENT

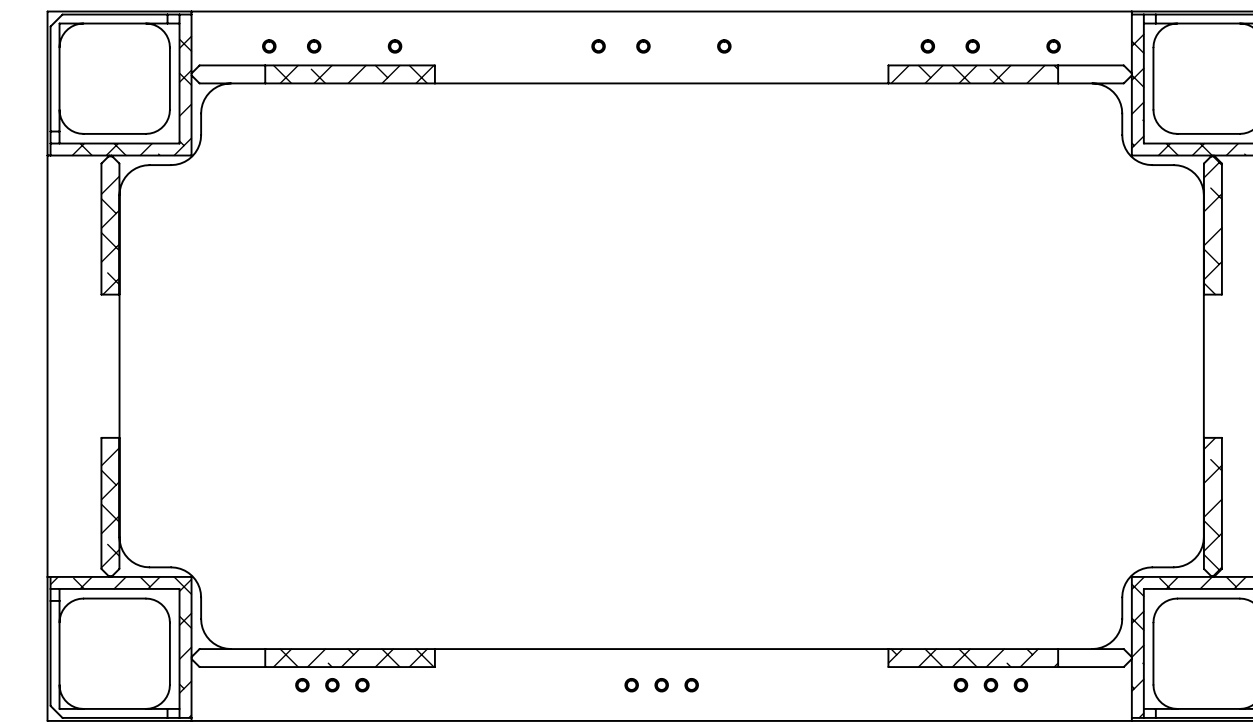
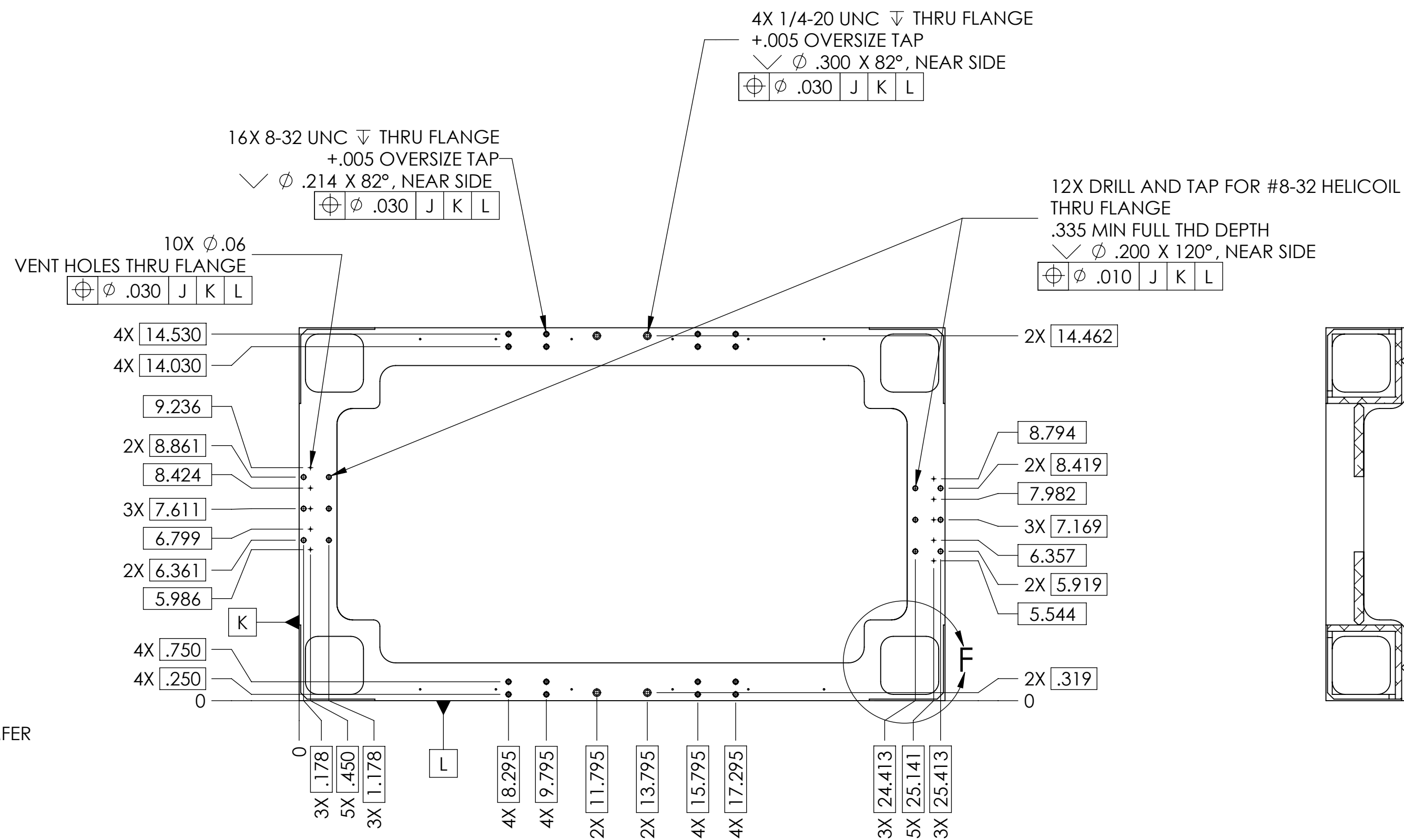
DESIGNER	C. ECHOLS	17 DEC 2006	SIZE	DWG. NO.	REV.
DRAFTER	B. MOORE	19 MAR 2009	D	D0900308	v4
CHECKER	M. MEYER	20 MAR 2009	SCALE: 1:4	PROJECTION:	SHEET 1 OF 4
APPROVAL					

D0900308_AsdLIGO_OMC_StructuralWeldment_PART_PDM_REV-V3-001_DRAWING_PDM_REV-V3-004

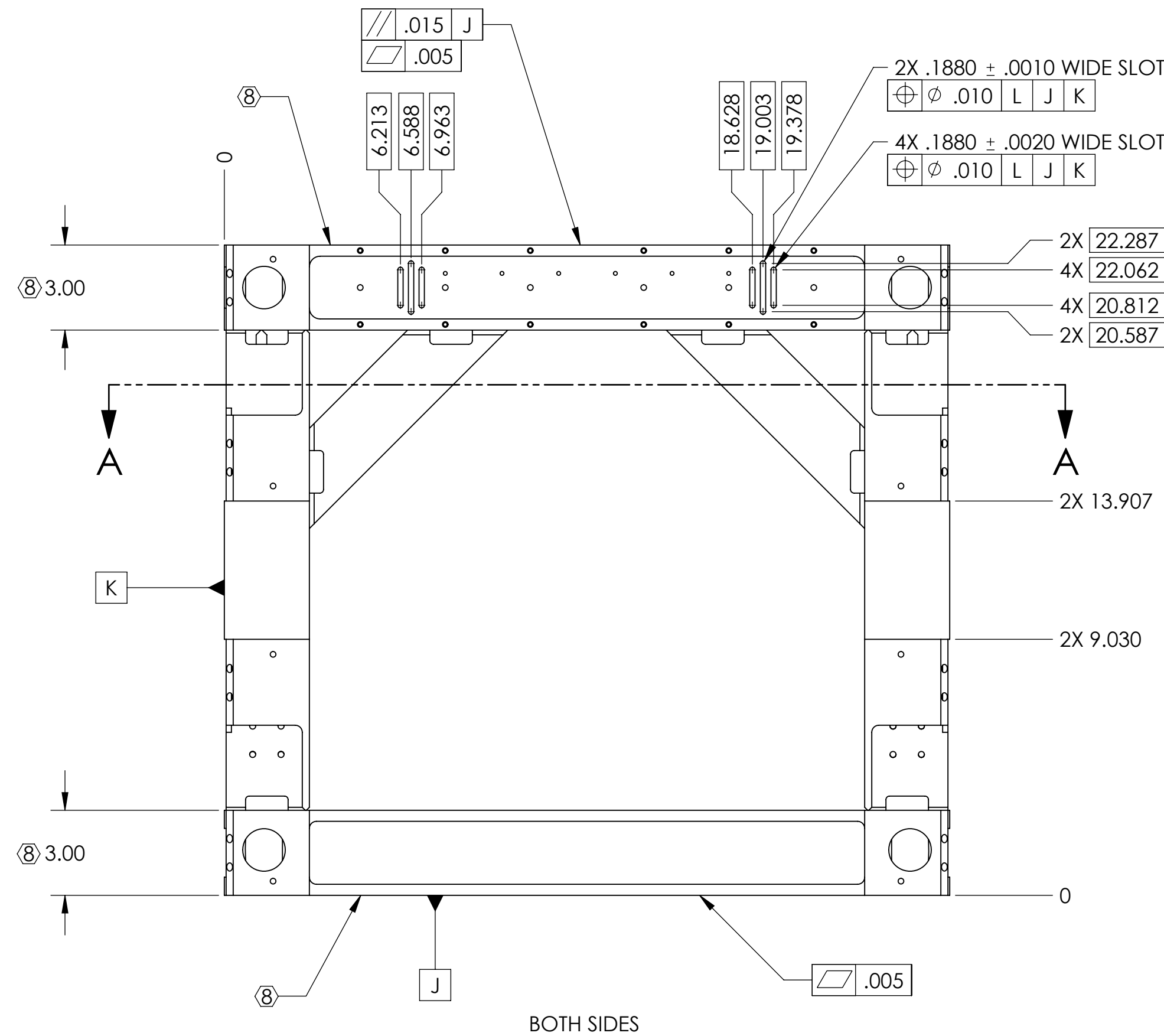
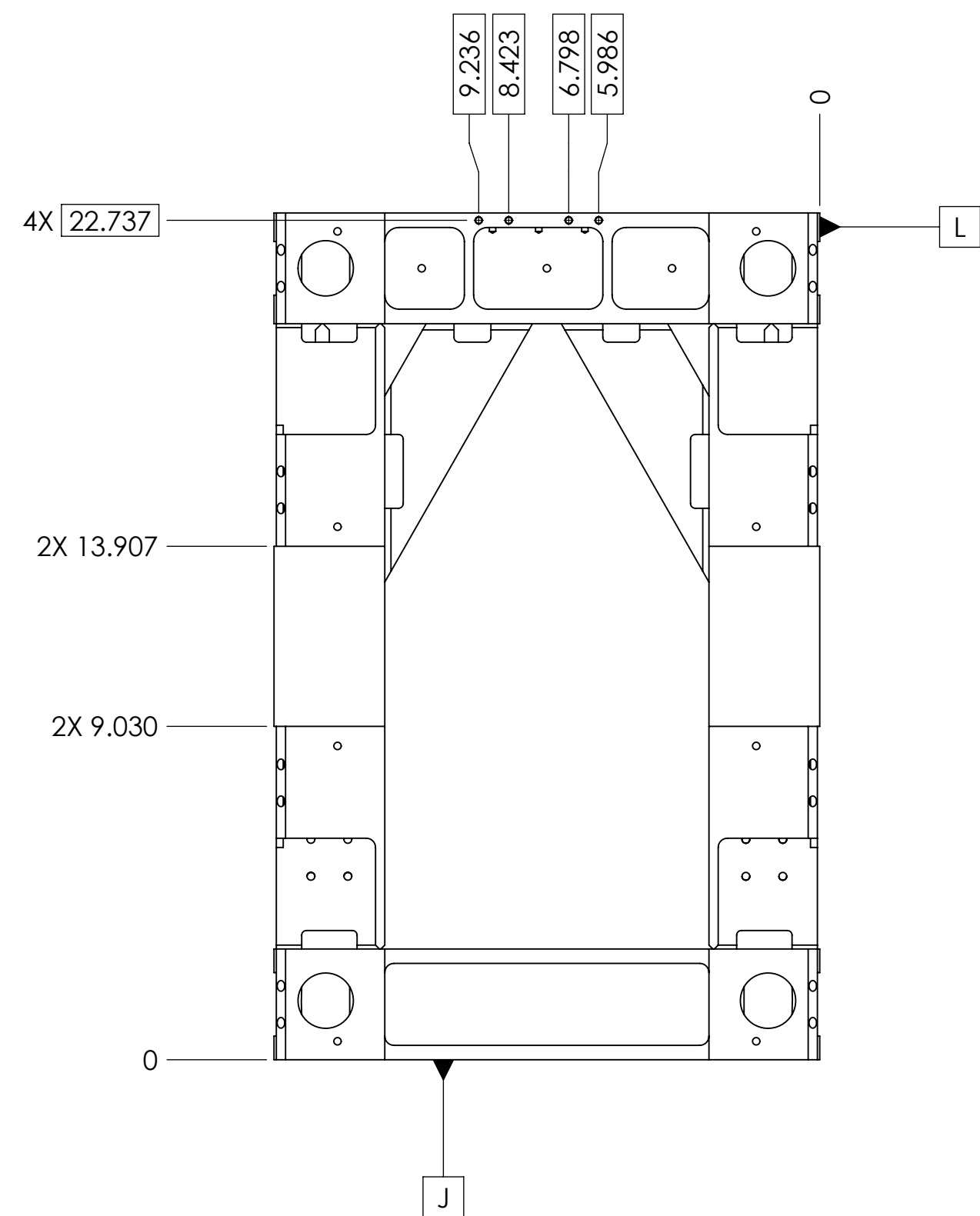




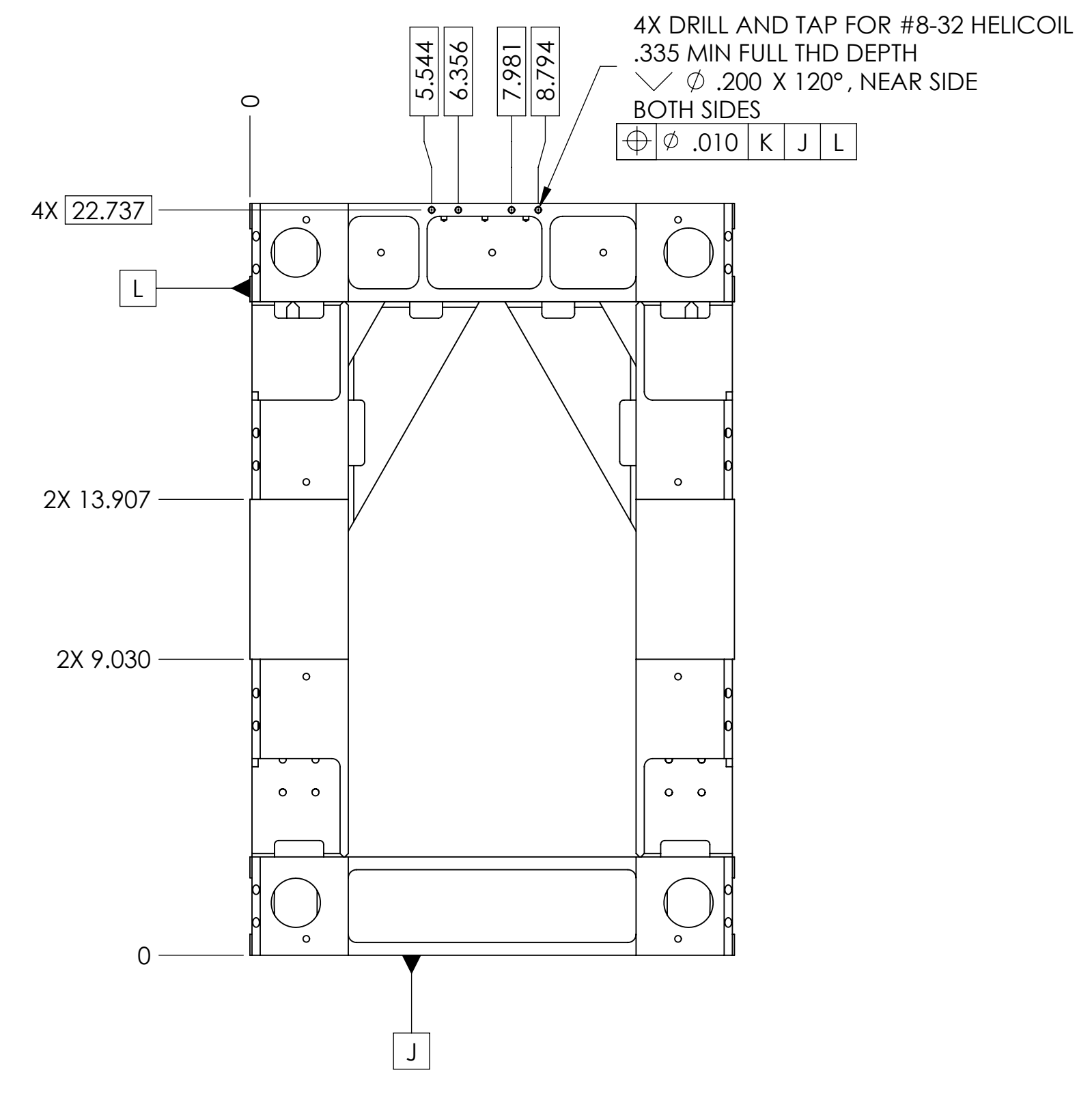
DETAIL F
SCALE 1:1



SECTION A-A



POST-WELD MACHINING



8

7

6

5

4

3

2

1

H

G

F

E

D

C

B

A

H

G

F

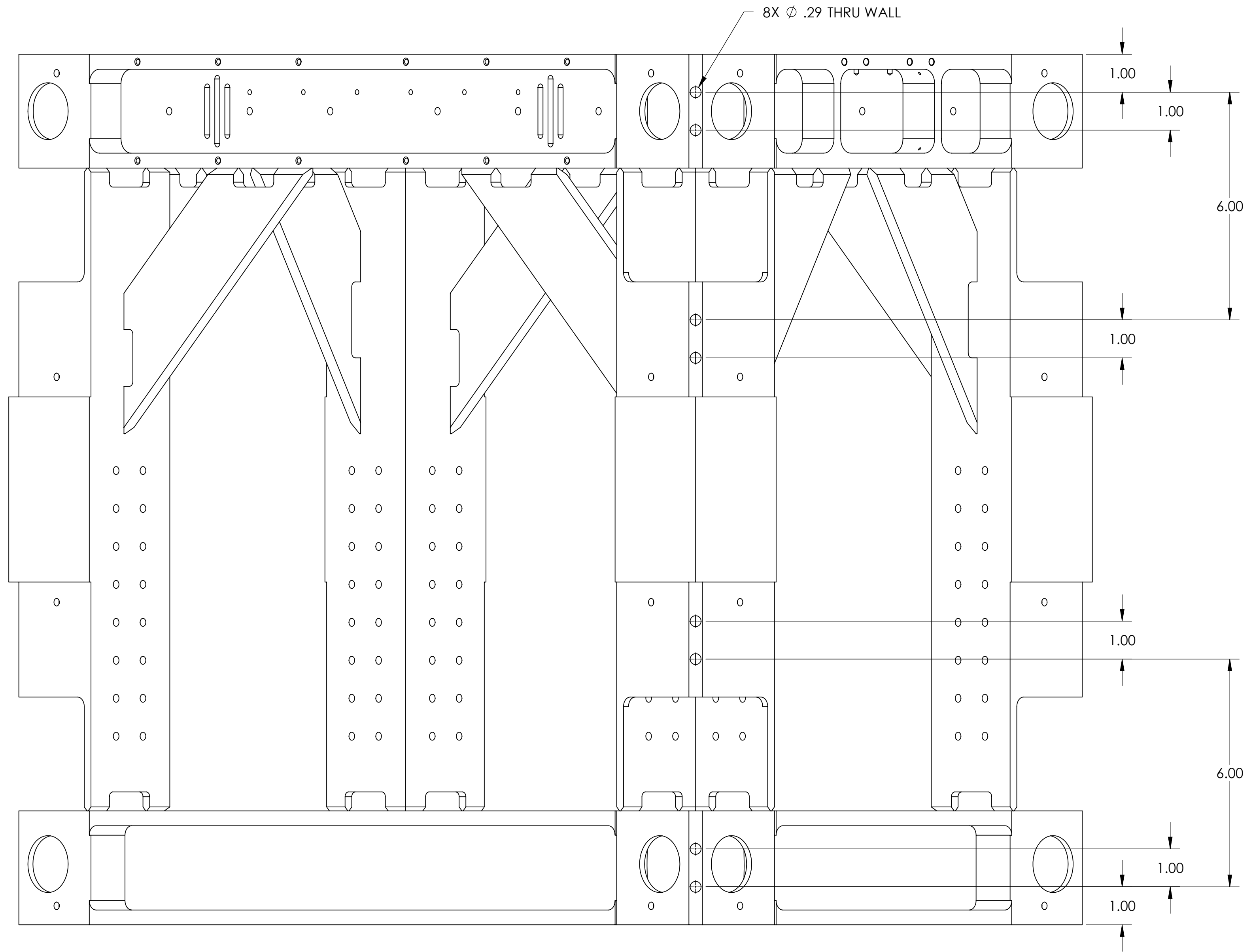
E

D

C

B

A



ALL FOUR CORNERS

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SIZE	DWG. NO.	REV.
D	D0900308	v4
SCALE: 1:2	PROJECTION:	SHEET 4 OF 4

DDP00308_AxialLIGO_CMC_Structural Weldment_PART.PDW,REV:V3-001, DRAWING.PDW,REV:V3-004

8

7

6

5

4

3

2

1